

Date: Monday, 5/14/2007 2:00:16 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 32344	Part Number	: D35701
Estimate Number	: 12679	Drawing Number	: D3570 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/14/2007	Type	: SMALL /MED FAB
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 5/15/2007
Previous Run	: 31866	Qty:	20
Written By	:		
Checked & Approved By			
Comment	: Est Rev:A New Issue 07-01-30 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S125	6061-T6 .125 Sheet	
		Comment: Qty: 0.0746 sf(s)/Unit Total: 1.4910 sf(s) 6061-T6 .125 Sheet Batch: M103156	
		Grain must be Along 4.63**	MM 07 05 15 (20)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3570 Dwg Rev: B Prog Rev: B	MM 07 05 15 (20)
		2-Deburr if necessary	MF - 07-05-22 (20)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MM 07 05 15 (20)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	JULY 05 15 (20) Canceled
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	(20) →
		1-Form as per Dwg D3570 Using DT8945	FF 07-08-02 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: H Date: 07.08.13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief-Eng.	Action Description Chief Eng	Sign & Date			
07/08/02 07/08/02 S.2		2 parts scrap dim 0.315 was found to be under the tol. R.C Hammer		Scrap and Destroy No replace	JF 07/08/02	E	N/A	S 07/08/02

NOTE: Date & initial all entries

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User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32344

Part Number: D35701

Job Number:



Seq. #: Machine Or Operation:

Description :

2-Cut excess materialas per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 07-08-02

20

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/02 X/8

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 01.08.10

(18)

8.0 POWDER COATING POWDER COATING



M 104846

18X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 01.08.11

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Counted

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

07/08/13 (19)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.13

Job Completion



07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

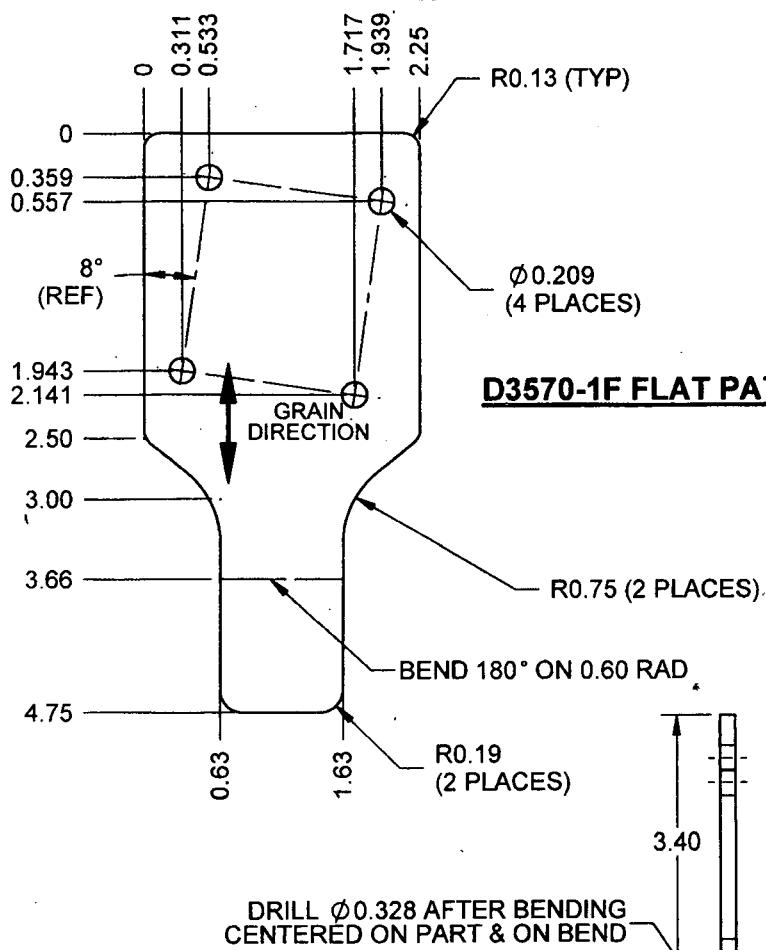
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

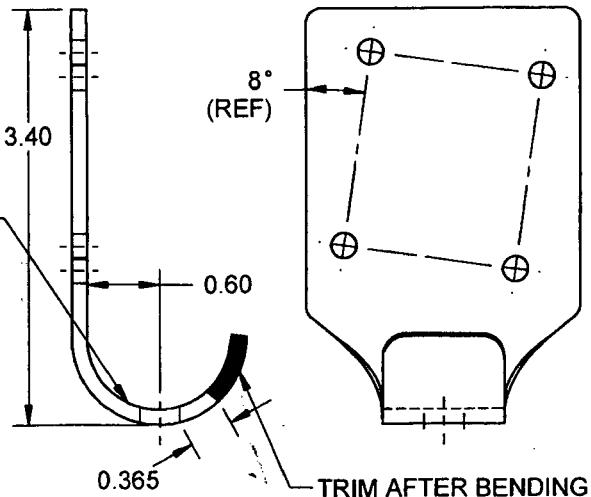
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3570	REV. C SHEET 1 OF 1
DATE 07.06.01	TITLE BRACKET	SCALE 2:3	

REV	DATE	DESCRIPTION
A	07.02.07	NEW ISSUE
B	07.04.16	CHANGE BEND RAD TO 0.60 FROM 0.50
C	07.06.01	UPDATE DIMS FOR CLARITY



**D3570-1 BRACKET SHOWN
(MAKE FROM D3570-1F)**

**D3570-2 BRACKET OPPOSITE
(MAKE FROM D3570-1F)**



NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.125" THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3570-1-2" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	32344
Description: Bearpaw D3570 bracket	Part Number:	D3570-1
Inspection Dwg: 3570 Rev: B C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.209$	+0.005-0.001	0.209	✓		VERN	
B 2.25	+/- 0.030	2.254	✓		VERN	
C 4.75	+/- 0.030	4.758	✓		VERN	
D $\odot 0.359$	+/- 0.010	0.362	✓		VERN	
E 0.557	+/- 0.010	0.558	✓		VERN	
F 1.943	+/- 0.010	1.943	✓		VERN	
G 2.141	+/- 0.010	2.146	✓		VERN	
H 0.533	+/- 0.010	0.535	✓		VERN	
I 1.939	+/- 0.010	1.943	✓		VERN	
J 0.311	+/- 0.010	0.313	✓		VERN	
K 1.717	+/- 0.010	1.720	✓			
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	07/05/15	Date:	07/05/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	